

इंटरनेट

मानक

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Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6734 (1972): Cut Lath and Lath Nails [PGD 31: Bolts, Nuts and Fasteners Accessories]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



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*Indian Standard*  
SPECIFICATION FOR  
CUT LATH AND LATH NAILS

“पुनर्गठित १९८०”  
“REAFFIRMED 1990”

**1. Scope** — Requirements of cut lath and lath nails made of steel.

**2. Material** — The nails shall be manufactured from mild steel wire conforming to IS : 280-1962 'Specification for mild steel wire for general engineering purposes (*revised*)' having a minimum ultimate tensile strength of 550 MPa and satisfying the bend test given in 7.1.

**3. Dimensions and Tolerances** — Shall be as given in Table 1.

**3.1** The eccentricity and ovality tolerances of the centre of the nail head with respect to the axis of the shank shall be as given below:

For nails with shank diameter  $\geq 2$  mm; 12 percent of shank diameter, *Max*

For nails with shank diameter  $< 2$  mm; 14 percent of shank diameter, *Max*

**4. Designation** — The nails shall be designated by the size, length and number of this standard.

*Examples:*

Cut Lath Nail 1.80  $\times$  15 IS : 6734

Lath Nail 2.00  $\times$  40 IS : 6734

**5. General Requirements** — The nails shall be machine made and may have die marks and feeding knife marks on the shank. They shall be uniformly circular in section, straight, free from wasters and shall have sharp points. The heads shall be properly formed and concentric with the shank.

**6. Finish** — Nails shall be supplied plain finished.

**7. Test**

**7.1 Bend Test** — Suitable test pieces of nails when cold shall not break or develop cracks, when doubled over either by pressure or by blows from a hammer until the internal radius is equal to the diameter of the test piece and the sides are parallel.

**8. Packing** — Nails of different sizes and types shall be packed in separate containers.

**8.1** Nails below 25 mm in length shall be packed in cardboard boxes and the net weight of each box shall be 0.5 kg. The nails may also be supplied in gunny bags and the net weight of each bag shall be 50 kg.

**8.2** Nails above 25 mm and up to 40 mm in length shall be packed in cardboard boxes and the net weight of each box shall be 2.5 kg. The nails may also be supplied in gunny bags, and the net weight of each bag shall be 50 kg.

**9. Scale of Sampling and Criteria for Conformity**

**9.1 Lot** — In any consignment all the packages of nails of the same type and size manufactured under essentially similar conditions shall be grouped together to constitute a lot.

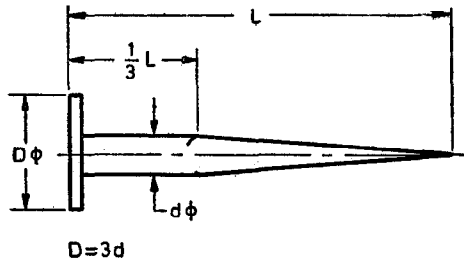
**9.2 Selection of Samples** — The number of nails to be selected at random from the lot shall depend on the size of the lot and shall be in accordance with col 1 and 2 of Table 2. The nails shall be selected from at least 25 percent of the packages.

Adopted 8 December 1972

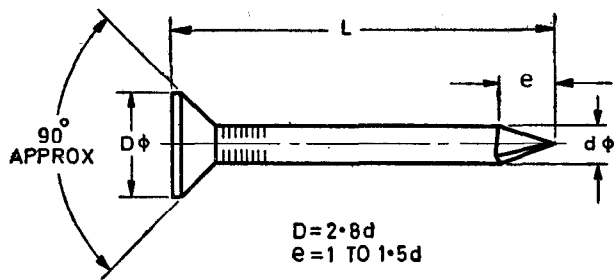
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TABLE 1 DIMENSIONS AND TOLERANCES OF CUT LATH AND LATH NAILS  
(SIZE 1.25 TO 2.24 mm)  
( Clause 3 )

All dimensions in millimetres.



CUT LATH NAIL



LATH NAIL

Size $d$ (Shank Diameter)		Head Diameter $D$		Length $L$		Approximate Number of Nails per kg	
Basic	Tolerance	Basic	Tolerance	Basic	Tolerance percent	Cut Lath	Lath
1.25	$\pm 0.04$	3.8	$\pm 0.19$	5	$\pm 1.0$	9 770	—
1.60	$\pm 0.04$	4.8	$\pm 0.24$	10	$\pm 1.0$	4 100	—
1.80	$\pm 0.04$	5.4	$\pm 0.27$	10	$\pm 1.0$	3 280	—
				15	$\pm 1.0$	2 310	—
				20	$\pm 1.0$	1 370	—
	$\pm 0.04$	5.0	$\pm 0.25$	20	$\pm 1.0$	—	2 240
				25	$\pm 1.2$	—	1 740
2.00	$\pm 0.4$	6.0	$\pm 0.30$	20	$\pm 1.2$	1 280	—
				25	$\pm 1.2$	1 060	—
	$\pm 0.4$	5.6	$\pm 0.28$	20	$\pm 1.2$	—	1 850
				25	$\pm 1.2$	—	1 430
				30	$\pm 1.2$	—	1 170
				40	$\pm 1.5$	—	970
2.24	$\pm 0.04$	6.7	$\pm 0.34$	30	$\pm 1.2$	860	—
				40	$\pm 1.5$	800	—

**Note**— The number of nails per kilogram is likely to vary to a considerable extent. The figures given in the table are intended only for guidance to the purchaser.

TABLE 2 SCALE OF SAMPLING AND CRITERIA FOR CONFORMITY

(Clauses 9.2, 9.3.2, 9.4.1 and 9.4.2)

Approximate Number of Nails in the Lot	For Visual and Dimensional Characteristics		For Bend Test	
	Number of Nails to be Selected	Permissible Number of Defective Nails	Sub-sample Size	Permissible Number of Defective Nails
(1)	(2)	(3)	(4)	(5)
Up to 1 000	32	5	8	0
1 001 „ 3 000	50	7	13	0
3 001 „ 10 000	80	10	20	0
10 001 „ 35 000	125	14	32	1
35 001 and above	200	21	50	2

**Note** — The sampling plan accepts the lots containing 7 percent or less defectives in respect of visual and dimensional characteristics more than 95 percent of the times. In the case of bend test the lot containing 1.5 percent or less defectives will be accepted more than 95 percent of the times.

### 9.3 Visual and Dimensional Characteristics

**9.3.1 Number of tests and criteria for conformity** — All the nails selected as in 9.2 shall be examined for manufacturing defects, dimensions and finish.

**9.3.2** The lot shall be considered as conforming to the requirements of these characteristics if the number of nails examined for characteristics mentioned in 9.3.1 and found defective does not exceed the corresponding acceptance number given in col 3 of Table 2.

### 9.4 Bend Test

**9.4.1 Number of tests and criteria for conformity** — The number of nails to be selected for carrying out bend test shall be according to col 4 of Table 2. These nails shall be selected from those already inspected according to 9.3.1 and found satisfactory.

**9.4.2** The lot shall be considered as conforming to the requirements of bend test if the number of nails failing to pass this test does not exceed the corresponding acceptance number in col 5 of Table 2.

**9.5** The lot shall be considered as conforming to the requirements of the specification if it satisfies 9.3.1 and 9.4.1.

**10. Marking** — All packages of nails shall be marked with the following information:

- Manufacturer's name or trade-mark,
- The type of nail,
- The size ( shank diameter ) and length of nail, and
- Net weight of the package.

**10.1 ISI Certification Marking** — Details available with the Indian Standards Institution, New Delhi 1.

## EXPLANATORY NOTE

Subsequent to the decision to revise IS : 723-1961 'Specification for mild steel wire nails ( revised )' splitting it into six individual standards each covering only one type of nail, the above standard has been prepared. In this the following additional features have been incorporated:

- Tolerances for eccentricity and ovality of nail heads have been specified.
- The sampling plan has been suitably modified to permit allowable percentage of defective nails from 4 percent to 7 percent.